

Work Order ID 163227

Monday, June 26, 2017 2:24:01 PM

163227

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Item ID: D3121-23 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearing
Start Date: 6/26/2017 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 7/26/2017 Req'd Qty: 50.00 ***50*** Customer:

Reference: **DAS 13 9-89**
Approvals: Process Plan: **DAS 13 9-89** Date: **JUN 26 2017** Tooling: Date:
QC: Date: SPC (Y/N): Date:
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3121	Rev E								

100

0.00

100

Purchasing

Purchasing

PURCHASING

Memo

0.00

Issue P/O: **36828** Bearing as per Dwg D3121 Possible Supplier:
SKF P/N: 61900-2Z or KML P/N: 6900-ZZ Material release note is required

50**JUN 26 2017****DAS 13 9-89**

110

0.00

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

1.00

Ensure Material Release Note is attached

50x Sp 17-6-28

120

0.00

120

QC

Quality Control

QC6- All purchased or subcontracted products

Memo

0.00

Inspect diimensions as per Dwg D3121 and attached certification Dwg Rev ____

50**DAS 38 9-89**
JUL 03 2017

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Item ID: D3121-23

Revision ID:

Item Name: Bearing

Start Date: 6/26/2017 Start Qty: 50.00

Required Date: 7/26/2017 Req'd Qty: 50.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>Sto18</u>	0.00				<u>50</u>		JUL 03 2017	<u>DAS</u> <u>5</u> <u>9-89</u>
130									
Packaging	Memo	0.50							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	5.00							
Quality Control									

JUL 03 2017

Picklist Print

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Work Order ID: 163227

163227

Parent Item: D3121-23

D3121-23

Parent Item Name: Bearing

Start Date: 6/26/2017

Required Date: 7/26/2017

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP A: 04.02.19 New Issue KJ/DS
IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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6900ZZ

Purchased

No

100

Each

0.0000

1

50

690077

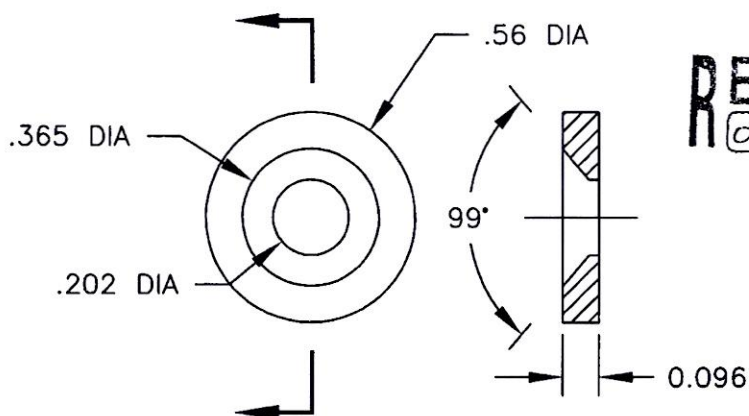
**

Bearing

50x Sp17-6-28

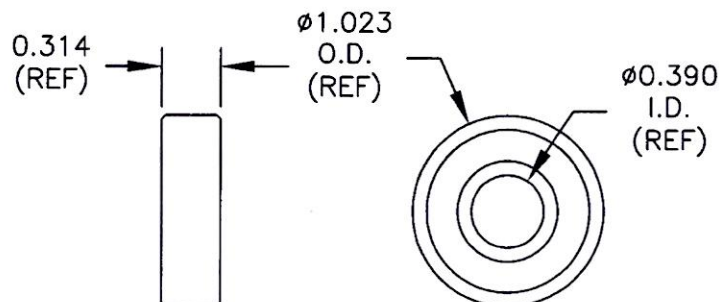


DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1



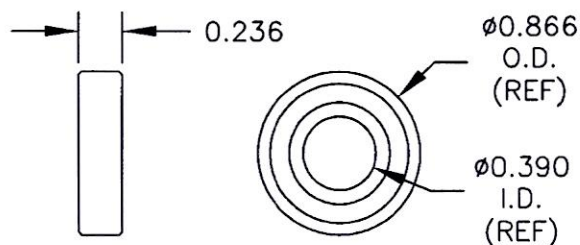
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



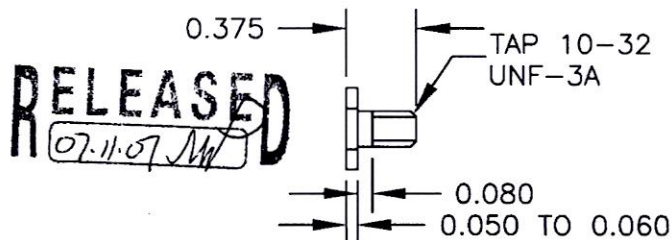
D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



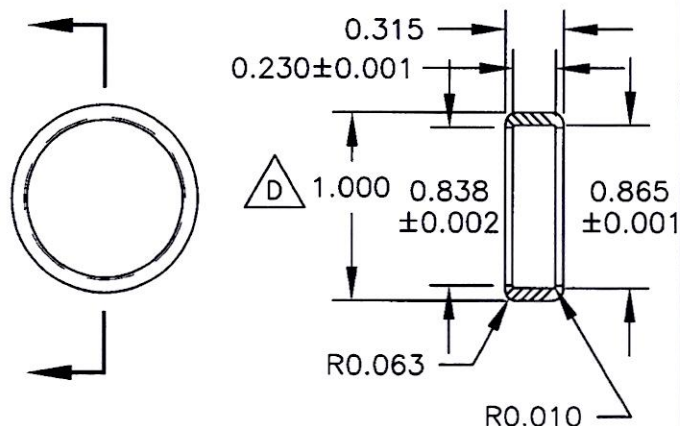
D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES



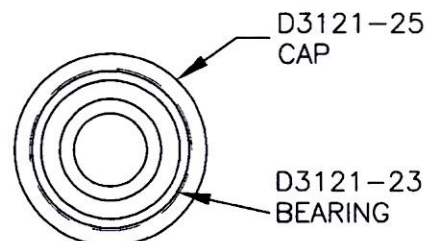
D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, 1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEMBLY (SCALE 1:1)

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36828**

Purchase Order Date 6/26/2017

PO Print Date 6/26/2017

Page Number 2 of 3

Order From :
MAIN INDUSTRIAL SALES LTD.
1475, TESSIER
HAWKESBURY, ON K6A 3S6
CA

VC-MAI001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613 632 3595

Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Total: \$71.00

4 6900ZZ

Bearing

6/28/2017
Yes
6/28/2017

50.00
Each

\$1.62 \$81.00

DAS
38
9-89

AS PER DWG D3121 REV. E
B163227

SA 7-6-28

Line Total: \$81.00

5 71500-15

10-R18#30 JOBBER
DRILL

6/28/2017
Yes
6/28/2017

20.00
Each

\$1.49 \$29.80

Line Total: \$29.80

Deliver To: CARL

6 71500-15

10-R15#F JOBBER DRILL

6/28/2017
Yes
6/28/2017

20.00
Each

\$3.72 \$74.40

Line Total: \$74.40

Deliver To: CARL

Note:

6/26/2017

MAIN INDUSTRIAL SALES LTD.

1475 TESSIER ST.
HAWKESBURY ON K6A 3S6
Phone: (613) 632-3595 Ext. Fax: (613) 632-0262
sales@mainindustrialsales.com

Packing Slip

DATE June 27, 2017
NUMBER 0000208925
CUSTOMER NO. DART

BILL TO:

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON K6A 1K7

SHIP TO:

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON K6A 1K7

(613) 632-5200 Ext.

(613) 632-5200 Ext.

P.O. NUMBER	SALESPERSON	ORDER DATE	REQ. DATE	ORDER NUMBER		
36828	EB	27-Jun-17		0000208925		
F.O.B.	SHIP VIA		TERMS			
F.O.B. value	OUR TRUCK / LOCAL		NET 30 DAYS			
PART NUMBER DESCRIPTION		LOCATION	UOM	QUANTITY REQ. SHIPPED B.O.		
0-516X112CHBSS 5/16-1 X 1 1/2 18-8 HEX BOLTS YOUR PART #: 5/16-18-015C		26B7	EA	100	100	
0-516FWSS 5/16 18-8 FLAT WASHER YOUR PART #: 5/16WC		26A6	EA	200	200	
0-716X5CHBSS 7/16-14 x 5" HEX BOLTS 18-8 STAINLESS YOUR PART #: 7/16-14-050C		26C7	EA	50	50	
0-69002ZKML ✓ KML BALL BEARING YOUR PART #: 6900ZZ		6D6	EA	50	50	
10-R18#30 #30 PTD HSS JOBBER DRILL 118 PT BLACK		9C0	EA	20	20	
10-R15#F #F PTD HSS JOBBER DRILL 118 PT BLACK		COU	EA	20	12	8
SPH 6-28.						

50176-28

CERTIFICATE OF COMPLIANCE

RE: 6900-ZZ BEARING

To Whom It May Concern:

Our bearing rings and balls are made of high carbon chromium steel GCr15 which has a chemical composition equivalent to SAE 52100. The hardness of bearing rings is HRC 59-64 and HRC 60-65 for steel balls. Unless specify, bearings are 25-30% filled with Alvania No. 2 grease or Chevron SRI#2 grease or equivalent.

Stella Fan
Phone: 905-629-4255
Fax: 905-629-2358

